



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D4931-3

Job Sheet 172554



Part No: D4931-3

Job Qty: 10 ea

Part Name: Engine Fitting (For B3 Models)



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 2/20/18

Job Tracking No:

Due Date: 4/18/18

Created By: Michelle Gagnon-Donovan

Type: SOLD

Description:

Note: DWG REV A SHEET 2 IPP REV:A NEW ISSUE 13-09-16 JLM VERIFIED BY:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	10 Ea	4/17/18	4/17/18	0.00	0.00	Start Up Machining-3		18/03/05
100	Doosan	10 pcs	4/17/18	4/17/18	0.52	9.90	Doosan		18/03/05
110	QC	10 pcs	4/17/18	4/17/18	0.00	0.00	QC2 Machining-3		18/03/05
112	Mill Conv	10 pcs	4/18/18	4/18/18	0.00	3.82	Mill Conv 1		18/03/05
115	QC	10 pcs	4/18/18	4/18/18	0.00	0.00	QC2 Machining-3		18/03/14
120	QC	10 pcs	4/18/18	4/18/18	0.00	0.00	QC8 Machining-3		18/03/22
130	Packaging	10 pcs	4/18/18	4/18/18	0.00	0.00	Packaging3-2		MAR 2 8 2018
140	QC21-SA	10 Ea	4/18/18	4/18/18	0.00	0.00	QC21		MAR 2 8 2018

Part Op 100 - Machine as per folio FB210

Descriptions: 112 - DRILL HOLES AS PER REQUIRED

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M303R2.000	303 Round Bar 2"	1.5000 ft (.15 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M303R2.000	2	63	0

Part Specifications

Specifications could not be found.

Plex 2/20/18 12:32 PM Dart.Gagnon.Michelle

DART AEROSPACE LTD

Work Order:

172554

~~169900~~

Description: EAPS P2 Engine Fitting

Part Number:

D4931-3

Inspection Dwg: D4931

Rev: A

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FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1-1/16-12 UN 2A	Maj: 1.0608 Min: 1.0494	1.054	✓		MJP-04	vern
M.O.W.	Maj: 1.0995 Min: 1.0938	1.097	✓			
0.13 x 45°	+/-0.030 x +/-0.5°	0.130 x 45°	✓			
Ø0.063	+0.004/-0.001	0.065	✓			
0.08	+/-0.030	0.072	✓			
0.906	+/-0.010	0.906	✓			
0.13	+/-0.030	0.131	✓			
0.25	+/-0.030	0.252	✓			
0.938	+/-0.010	0.935	✓			
1.927	+/-0.010	1.928	✓			
0.250	+/-0.010	0.247	✓			
0.424	+/-0.010	0.424	✓			
0.315	+/-0.010	0.315	✓			
0.185	+/-0.010	0.185	✓			
37°	+/-0.5°	37°	✓			
0.33	+/-0.030	0.330	✓			
34°	+/-0.5°	34°	✓			
0.532	+/-0.010	0.532	✓			
1.063	+/-0.010	1.060	✓		MJP-04	vern
0.594	+/-0.010	0.594	✓			
0.791	+/-0.010	0.787	✓		MJP-04	vern
1.188	+/-0.010	1.188	✓			
1.582	+/-0.010	1.582	✓		MJP-04	vern
Ø0.238	+0.004 -0.001	0.239	✓		Caliper	JCL-08

Measured by:

Date:

Audited by:

Date:

Preliminary Approval:

Date:

Rev	Date	Change	Revised by	Approved
A	14.06.24	New Issue	KJ	



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Container No: S047934



Part: D4931-3

Job No: 172554

Serial No/Batch: S047934

Revision:

Inspector:

Date: 03/05/18